

Work Order ID 84185

84185

Page 1

May-07-12 11:04:54 AM

Item ID: D206-667-201

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Aft

Start Date: 07/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/07 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D206-667-241

Rev C (DEO)

DSI 9471

Rev A

100

100

DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and create labels as per PPP D206-667-201 CHG004

DAS 16

12/6/16

for MLJ 12-7-16

110

110

Packaging

Packaging

Packaging

Memo

0.00

0.00

mo 12-6-15

Pro

W/O: 84185		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-667-201 PAR #: _____ Fault Category: X - Tube NCR: Yes No DQA: OK Date: 12/07/19
 Resolution: _____ Disposition: use as is QA: N/C Closed Date: 2/7/20

NCR: 12-1600		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/6/18	120	# bending passes is below dwg.	GP 12/6/18	Acceptable No history of fatigue issues	N/A	DQA 18 12/07/18	GP 12/6/18	DQA 16 12/07/18

NOTE: Date & initial all entries

Work Order ID 84185

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Mgy-07-12 11:04:54 AM

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N900040100

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Revision ID:

Item Name: Crosstube Aft

Stop *NS2*

Start Date: 07/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

120

CNC Bend 2

CNC Alpha 160 Bender

BENDING MACHINE - CROSSTUBES

Memo

Bend tube as per Dwg D206-667-241 using CNC bender program 206B-AF and Folio FT _____

0.00

0.00

no/RN

12-6-18

130

130

QC

Quality Control

QC15- Crosstube Dimensional Check

Memo

0.00

0.00

8/12/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Item Name: Crosstube Aft

Stop *NS2*

Start Date: 07/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Crosstubes	0.00							
140									
Crosstubes	Memo	0.00							
Crosstubes	1-Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576								
	2-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576. (DRILL 3 HOLES ON BOTH SIDES)								
	3-Flip tube and switch drilling Jigs from right to left, left to right. Locate tube using "T" pins off holes drilled in previous step.								
	4-Drill pilot holes (3/16") as per Dwg D206-667-241 using drill Jig DT8575 & DT8576								
	5-Drill & ream holes as per Dwg D206-667-241 using drill Jig DT8575 & DT8576. Check dimensions between holes on all four sides to ensure proper alignment. Use DT8583 & 8584 SUPPORT Jigs. (DRILL 3 HOLES ON BOTH SIDES)								
	6-Drill rivet holes as per Dwg D206-667-241 using drill Jig DT8788								
	7-C'sink holes as per Dwg D206-667-241								
	8-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241								
	9-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-241 Inside of Cuff (Do not engrave on outside of tube)								

Rm

12-6-19

Rm

12-6-20

Rm

12-6-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item Name: Crosstube Aft

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Start Date: 07/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Crosstubes Chemical Conversion	0.00							
150									
HandFXtube	Memo	0.00							
Hand Finishing Crosstubes									
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control									

PTO →

So it looks

W/O: 84185		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
7/26/70	# 150/160	Move step # 100 + 160 to after step # 200 See B# 84184					

Part No: D206-667-201 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Setup Start *NS1*

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Item Name: Crosstube Aft

Stop *NS2*

Start Date: 07/05/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Outsource process - NDT per QSI038 4.1	0.00							
180									
Outsource2	Memo	0.00							
Outsource process - NDT	CROSSTUBES								
190		0.00							
190	Packaging								
Packaging	Memo	0.00							
Packaging	Ensure copy of NDT results attached to work order.								
200	QC6- Inspect dimensions to drawing	0.00							
200									
QC	Memo	0.00							
Quality Control	Inspect for damage & ensure results are as per Dwg D206-667-201								

CL 12/06/22 (1)

12/4/22 (1)

(1)

* chemical coat as per order (1) 12/06/27

* QC7 inspect chemical coat 12/07/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Setup Start *NS1*

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Item Name: Crosstube Aft

Stop *NS2*

Start Date: 07/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

210

SprayPaint

SprayPaint

0.00

0.00

Memo

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME: 121746

Start Time: 7:45

Finish Time: 8:15

PAINT: 120985

Start Time: 1:45

Finish Time: 2:15

12-7-5

220

220

QC

Quality Control

QC14- Inspect Spray Paint

0.00

0.00

Memo

Wrap in plastic bag to protect from scratches

8/10/12

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Aft

Stop ***NS2***

Start Date: 07/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Crosstubes	0.00							
230									
Crosstubes	Memo	0.00							
Crosstubes	1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper, clean the area with 4105S wash 'n' wipe								
	2-Install supports with Proseal 890 per DSI9565 and QSI 015 A/R Proseal 890 Batch: <u>121287</u>								
	3- Torque bolts as per dwg								
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									

AP 12-7-14

5/7/10/16

12/7/10/16 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 84185

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May-07-12 11:04:54 AM

Item ID: D206-667-201

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Aft

Stop ***NS2***

Start Date: 07/05/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control									
270		0.00							
270	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD206-667-201								
	Location: <u>18 63</u>								
	PPP Rev: <u>0</u>								
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

DAS
16
59

12/17/16

12/17/16 SP

12/17/17

MF
12-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-07-12 11:04:58 AM

Page 1

Work Order ID: 84185

84185

Parent Item: D206-667-201

D206-667-201

Parent Item Name: Crosstube Aft

Start Date: 07/05/2012

Required Date: 31/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: New issue DD verified by:EC
11.08.08 PER ECN 11-615 DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-667-201TRN		Manufactured	No			110	Each	0.0000	1	1			
D206-667-201TRN					827913				**			MO 12-6-15	
Crosstube Turning Detail													
D2891-1		Manufactured	No			230	Each	24.0000	2	2			
D2891-1									**			AP 12-7-14	
2.25 Support													

Location	Loc Qty	Loc Code
LG052	24	
72822	1	
75176	1	
80160	3	
82277	19	

D3595-063-395		Manufactured	No			230	Each	62.0000	4	4			
D3595-063-395									**			AP 12-7-14	
RUBBER CUSHION													

Location	Loc Qty	Loc Code
LG051	62	
82223	62	

MS21920-20		Purchased	No			230	Each	120.0000	4	4			
MS21920-20									**			AP 12-7-14	
Clamp (per MIL-DTL-8783C)													

Location	Loc Qty	Loc Code
LG050	120	
116799	8	
120676	16	
121067	46	
121274	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 84185

Parent Item: D206-667-201

Parent Item Name: Crosstube Aft

84185

D206-667-201

Start Date: 07/05/2012

Required Date: 31/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-10A

Purchased

No

250

Each

296.0000

10

10

AN5-10A

Bolt

**

M122151

SP

Location

Loc Qty

Loc Code

ST337

296

118191

80

120630

14

120717

50

120770

2

121181

50

121243

100

AN5-30A

Purchased

No

250

Each

81.0000

10

10

AN5-30A

BOLT

**

Location

Loc Qty

Loc Code

ST339

81

117514

7

120423

19

120910

25

121259

30

AN5-32A

Purchased

No

250

Each

292.0000

4

4

AN5-32A

Bolt

**

12/1/10

SP

Location

Loc Qty

Loc Code

ST339

192

119328

27

119862

50

120423

75

120910

30

121415

10

ST340

100

121541

100

May-07-12 11:04:58 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 84185

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Parent Item: D206-667-201

D206-667-201

Parent Item Name: Crosstube Aft

Start Date: 07/05/2012

Required Date: 31/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN960JD516

NAS1149D0563J

Purchased

No

250

Each

0.0000

20

20

AN960JD516

Washer

D2872-043

Manufactured

No

250

Each

7.0000

2

2

D2872-043

Nut Plate Assembly

Location

Loc Qty

Loc Code

ST025

7

82601

7

Manufactured

No

250

Each

7.0000

2

2

D2872-045

D2872-045

Nut Plate Assembly

Location

Loc Qty

Loc Code

ST019

7

82602

7

Manufactured

No

250

Each

4.0000

1

1

D3039-3

D3039-3

Centre Drill

Location

Loc Qty

Loc Code

ST024

4

14761

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D206-667-201

Parent Item Name: Crosstube Aft

84185

D206-667-201

Start Date: 07/05/2012

Required Date: 31/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

250

Each

1,463.000

10

10

MS21042L5

Nut

Location

Loc Qty

Loc Code

300

300

121652

300

ST300

1163

116105

5

116548

43

117611

30

119109

1085

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

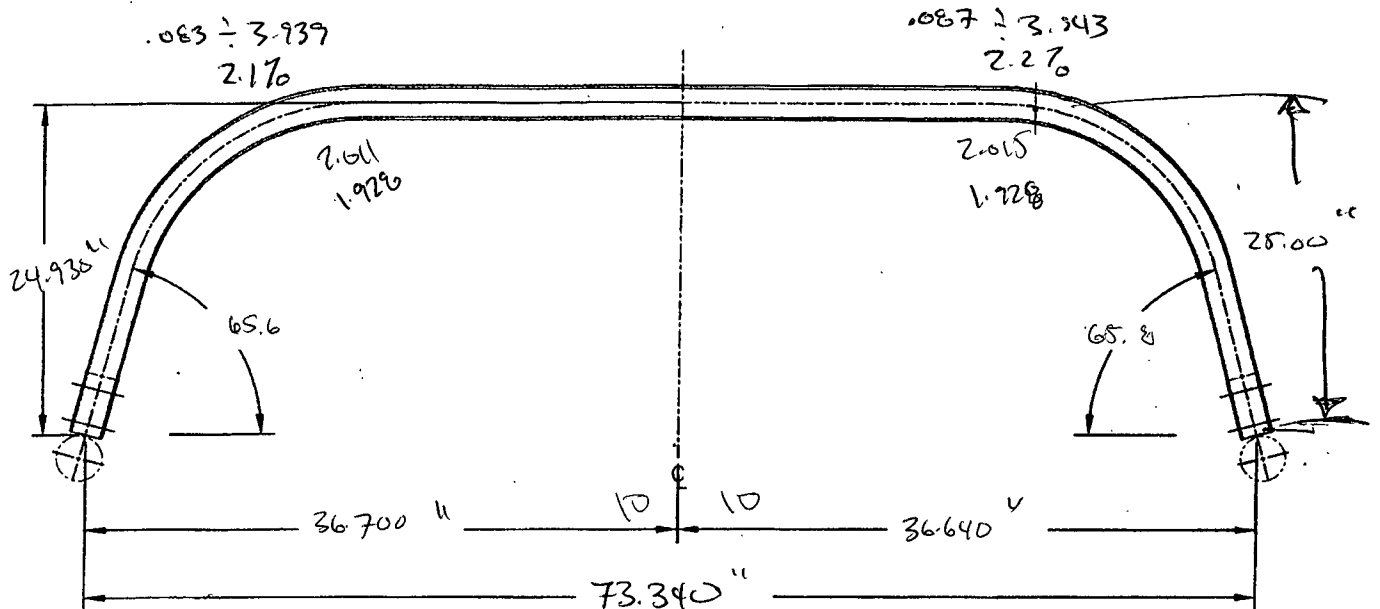
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	84185
Description: Crosstube High Aft (206B)	Part Number:	D206-667-201
Inspection Dwg: D206-667-241 Rev: C		Page 1 of 1

Required Dimension	Min	Max
Height	24.91	25.17
1/2 Span	36.47	36.73
Angle	65	67
Total Span	72.95	73.45



Comments
SIDE A = 2.21% crush @ 10 Passes
SIDE B = 2.2% crush @ 10 Passes
Acceptable 12/6/12

QC15 Inspection	<i>[Signature]</i>
Date	17 Dec 12

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.12.04	24-98 was 24.48	KJ/JM	
C	11.10.12	Dimensions updated per Dwg Rev C	KJ	<i>[Signature]</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C OR EARLIER REVISION
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 2 OR EARLIER REVISION
REF TCCA STC: SH01-5
REF FAA STC: SR01304NY
REF EASA STC EASA.IM.R.S.01179

PURPOSE:

For the D206-667-201 Crosstube Installation, the parts list was missing the required drill bit specified in Figure 5 of IIN-D206-667 and Figure 32-5 of ICA-D206-667.

CHANGE:

For the D206-667-201 Crosstube Installation, the included D3039-3 Center Drill is used to open the specified holes to $\varnothing 0.313"$. The hole must then be opened to $\varnothing 0.323" + 0.005/-0.000$. The parts list of IIN-D206-667 and ICA-D206-667 is amended as follows:

5.0 PARTS LIST (IIN-D206-667 REV. C OR EARLIER REVISION)
32.8 PARTS LIST (ICA-D206-667 REV. 2 OR EARLIER REVISION)

QTY -201	PART NUMBER	DESCRIPTION
X	D206-667-201	CROSSTUBE INSTALLATION, 206A/B HIGH AFT
1	D3039-3	CENTER DRILL (ADD)

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84165 M25
12/05/07

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.07.06
CERT. NO.: SH01-5
ISSUE NO.: 3

A	NEW ISSUE, NCR 09-005	CP	09.07.06
REV.	DESCRIPTION	BY	DATE
DESIGN	gp	DART AEROSPACE LTD	
DRAWN	gp	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9471	SHEET 1 OF 1
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	CENTER DRILL ADDITION	NTS
DATE	09.07.06	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item	Qty -241	Part Number	Description
1	X	D206-667-241	CROSSTUBE ASSEMBLY (206B HIGH AFT)
2	1	D6003-102	CROSSTUBE
3	2	D2891-1	SUPPORT
4	4	D3595-063-395	RUBBER CUSHION
5	4	MS21920-20	CLAMP (OR MS21920-21)
6	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6003-102
FINISHED LENGTH = 100.60±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-241" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 22.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS MECHANISMS ARE LOCATED ON CROSSTUBE CLAMPS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

REVISION TO
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NO. 84185 MLJ

12/05/07

UNDER REVIEW

[Signature] OK 11/08/03

RELEASED
[Signature] 08/11/12

DEO ATTACHED

C	REFORMAT/REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN C5-3, C4-3, D3-3); RELOCATED FLAG #6 (ZN A7-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	08.11.06		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D206-667-241	REV. C SHEET 1 OF 4
TITLE CROSSTUBE ASS'Y (206B HIGH AFT)	SCALE NTS
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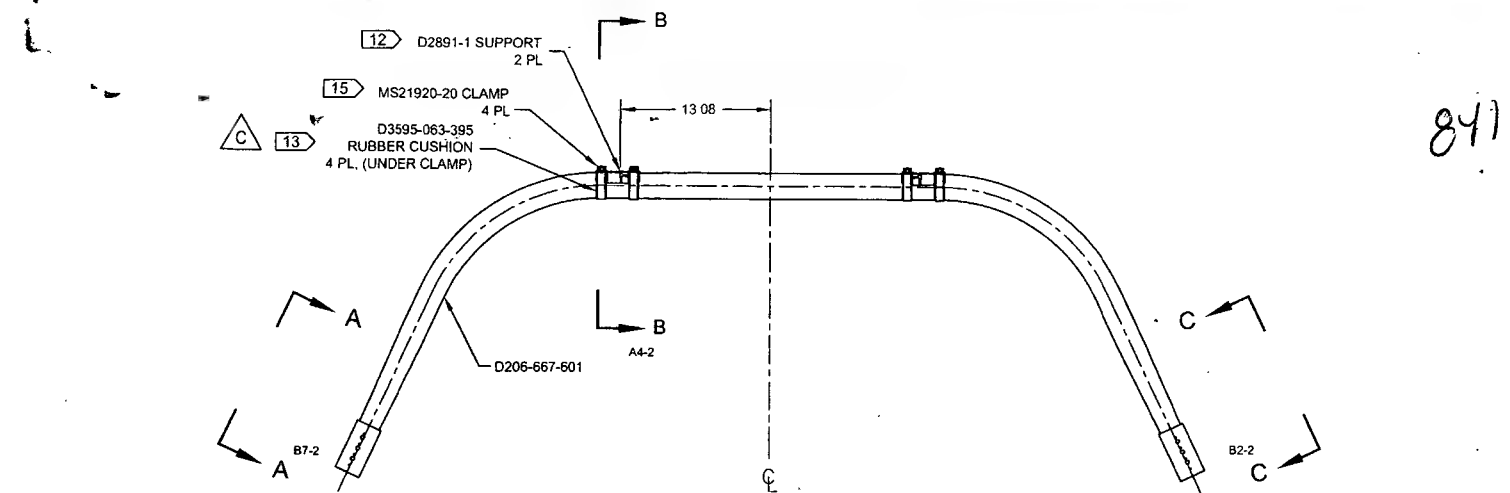
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

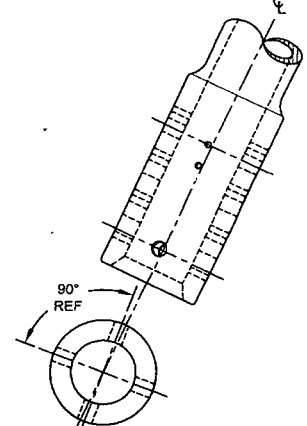
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

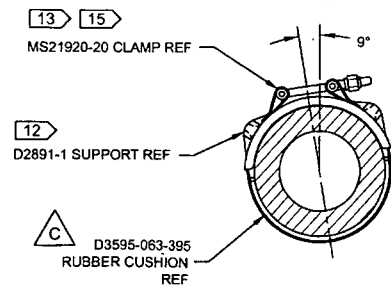


84105

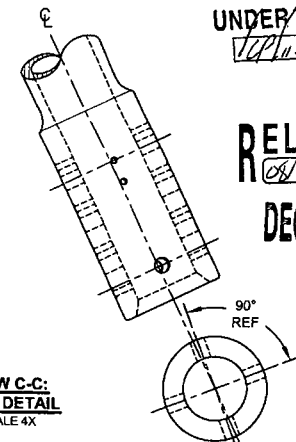


VIEW A-A:
CUFF DETAIL
SCALE 4X

D206-667-241
ASSEMBLY DETAIL
(VIEW LOOKING FWD)



SECTION B-B
SCALE 5X



VIEW C-C:
CUFF DETAIL
SCALE 4X

UNDER REVIEW
08/11/05/13 OK 08/11/05

RELEASED
08/11/12/MyD
DEO ATTACHED

DESIGN	9P	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9P	DRAWING NO.	REV. C
MFG. APPR.	9P	D206-667-241	SHEET 2 OF 4
APPROVED	9P	TITLE	SCALE
DE APPR.	9P	CROSSTUBE ASS'Y (206B HIGH AFT)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

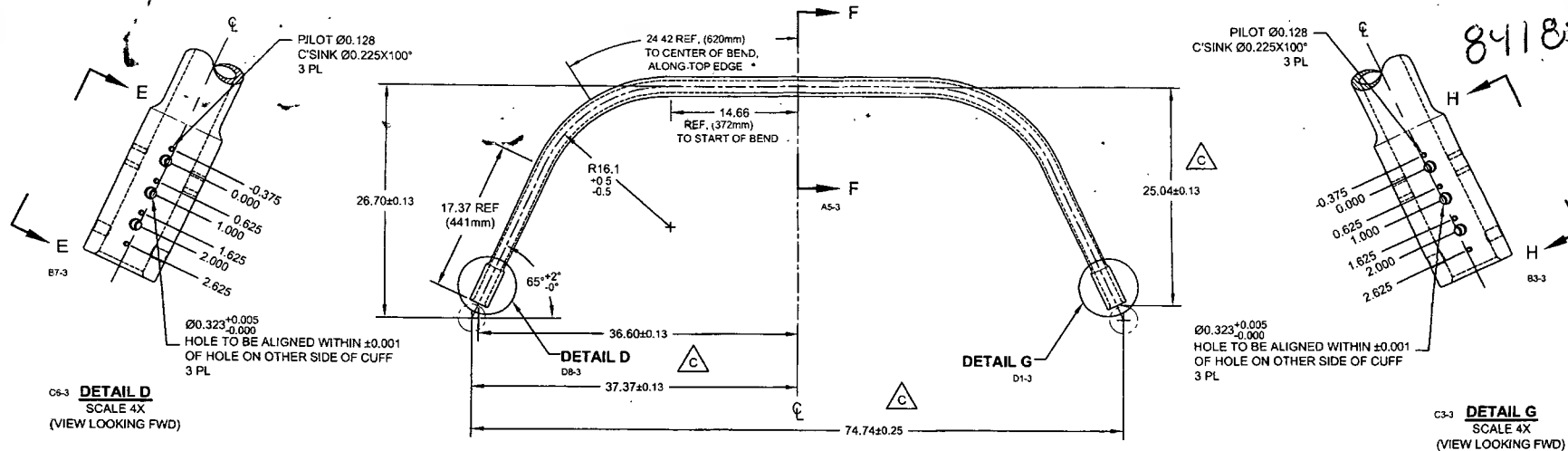
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

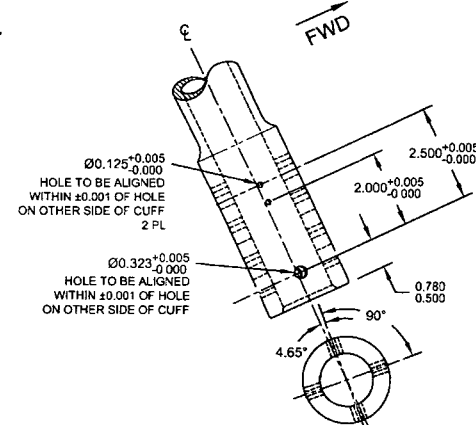
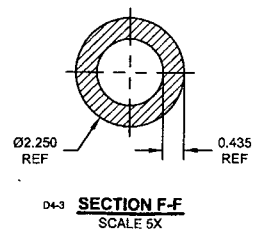
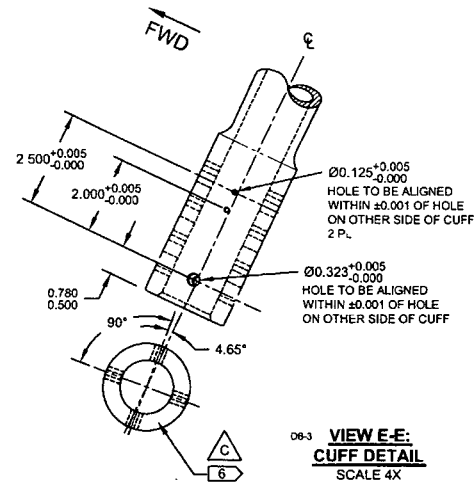
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D206-667-601
BENDING AND DRILLING DETAIL
(VIEW LOOKING FWD)



UNDER REVIEW
11/06/13 OK 11/06/13

RELEASED
DEO ATTACHED

DESIGN	97	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-241	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (206B HIGH AFT)	NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

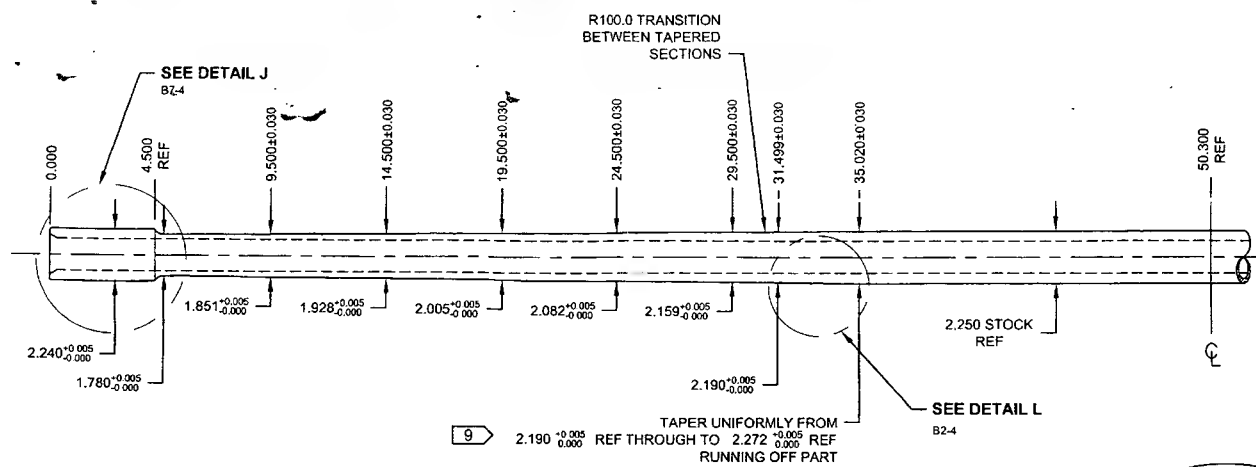
NOTE: Date & initial all entries

8-11-85

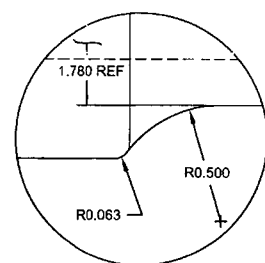
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JP 11/06/17 OK AP H.08.15

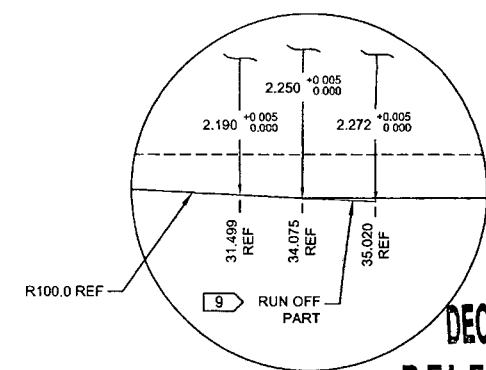
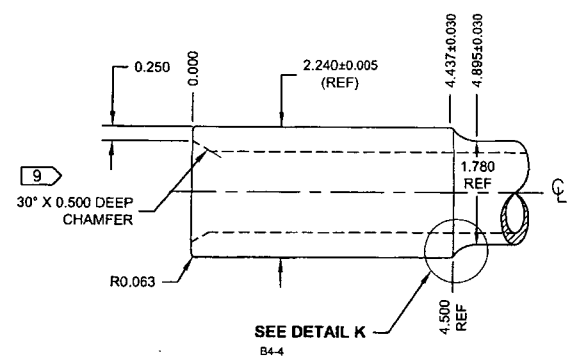
DEO ATTACHED
RELEASED
06/11/12



TURNING DETAIL



DETAIL K: CUFF TRANSITION
NOT TO SCALE



DESIGN	JP	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D206-667-241	SHEET 4 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASS'Y (206B HIGH AFT)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D206-667-241	TITLE CROSSTUBE ASS'Y (206B HIGH AFT)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D206-667-241-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN UP	CHECKED AS	MFG. APPR. M	APPROVED WD	DE APPR. H			
DATE 11.07.15	DATE 11.08.22	DATE 11.08.22	DATE 11/08/22	DATE 11/08/22			

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -241	Part Number	Description
6	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

6	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
---	-----	----------------	---

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-08-23
MA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



LIQUID PENETRANT TEST REPORT

P- 12189

CLIENT DART AeroSpace DATE JUNE 27/2012 PAGE 1 OF 1
ATTENTION LINDA / MATT ACUREN JOB NO. 188-12-CO270
ADDRESS 1270 A BENDEN ST. POWO No. -
HAWKESBURY, ON. WORK LOCATION SAME
ACCEPTANCE STD. ASTM 1417/OSI-030 REV./DATE 2005
PROJECT F.P.I. on cross tubes
ITEM(S) EXAMINED 9 PCS

JOB DESCRIPTION PROCEDURE No. LT 0002 REV./DATE 2008 TECHNIQUE No. LT 2 REV./DATE 2008
PART No. SEE RESULTS MATERIAL STEEL / ALUMINUM THICKNESS VARIOUS
SCOPE A DET FLUORESCENT PENETRANT INSPECTION WAS CARRIED OUT ON THE EXTERNAL SURFACE 100%

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNA FLUX BLACK LIGHT S/N 1859 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT 2LG7 MINIMUM DWELL TIME 10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O MINIMUM DRY TIME > 10 MIN. OTHER LABINO
DEVELOPER SK052 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 1098866 CAL DUE DATE JULY 28/2012
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/20°F ☐ -4°C/20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- ☒ METRIC ☐ IMPERIAL

W.O. #	CROSS TUBES	ACCEPT	REJECT
1 - 85335	" "	✓	
1 - 73809	" "	✓	
1 - 85402	" "	✓	
1 - 73808	" "	✓	
1 - 73806	" "	✓	
1 - 84784	" "	✓	
1 - 84185	" "	✓	
1 - 84527	" "	✓	
1 - 84526	" "	✓	

STEEL TUBES
ALUMINUM TUBES

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES
CLIENT REPRESENTATIVE Andy Sheldon PRINT At Sheldon SIGNATURE DTR # E-63661
TECHNICIAN (SIGNATURE): Mike Hersh REPORT REVIEWED BY:
NAME (PRINT): 1st TECHNICIAN NAME INITIALS
CGSB LEVEL 2 SNT LEVEL 2 CGSB LEVEL 2 SNT LEVEL 2
CGSB REG. No 6606 CGSB REG. No 6606

5.0 PARTS LIST

5.1 HIGH GEAR CROSSTUBES

Item	Qty -101/	Qty -201	Qty -103	Qty -203	Qty -105	Qty -205	Part Number	Description
	X						D206-667-101	CROSSTUBE INSTALLATION, 206A/B HIGH FWD
		X					D206-667-201	CROSSTUBE INSTALLATION, 206A/B HIGH AFT
			X				D206-667-103	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH FWD
				X			D206-667-203	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH AFT
					X		D407-667-105	CROSSTUBE INSTALLATION, 407 HIGH FWD
						X	D407-667-205	CROSSTUBE INSTALLATION, 407 HIGH AFT
1	1						D206-667-141	CROSSTUBE ASSEMBLY, 206A/B HIGH FWD
2		1					D206-667-241	CROSSTUBE ASSEMBLY, 206A/B HIGH AFT
3			1				D206-667-143	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH FWD
4				1			D206-667-243	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH AFT
5					1		D407-667-145	CROSSTUBE ASSEMBLY, 407 HIGH FWD
6						1	D407-667-245	CROSSTUBE ASSEMBLY, 407 HIGH AFT
10	*2	*2	*2		*2		D2891-1	SUPPORT
11				*2			D2892-1	SUPPORT
12						*1	D2894-1	SUPPORT
13	*4	*4	*4		*4		D3595-063-395	RUBBER CUSHION
14				*4			D3595-063-450	RUBBER CUSHION
15						*2	D3595-075-430	RUBBER CUSHION
16	*4	*4	*4		*4		MS21920-20	CLAMP
17				*4		*4	MS21920-22	CLAMP
18						*2	MS21920-25	CLAMP (OR MS21920-24)
19	4	4	4		4		AN5-32A	BOLT
20				4		4	AN5-34A	BOLT
21	4	4	4	4	4	4	MS21042L5	NUT (OR MS21042-5)
22	8	8	8	8	8	8	NAS1149C0563J	WASHER (OR AN960JD516)
23						*2	D3190-1	CHAFING SHIELD
40	*2		*2	*2	*2	*2	D2873-043	NUT PLATE
41	*2		*2	*2	*2	*2	D2873-045	NUT PLATE
42		2					D2872-043	NUT PLATE
43		2					D2872-045	NUT PLATE
44	10		10				AN5-7A	BOLT
45		10		10	10	10	AN5-10A	BOLT
46	4	10	4		4		AN5-30A	BOLT
47				4		4	AN5-32A	BOLT
48			12				AN970-4	WASHER (OPTIONAL)
49		6					MS21042L5	NUT (OR MS21042-5)
50	10	12	10	10	10	10	NAS1149C0563J	WASHER (OR AN960JD516)
60		1					D3039-3	CENTER DRILL (TOOLING, NOT INSTALLED)

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-141/-143/-241/-243 & D407-667-145/-245
ASSEMBLIES ABOVE

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Revision: D

Date: 11.05.01